

Work Order ID 84295

Wednesday, May 09, 2012 11:12:03 AM

Blue
84295

Page 1

Item ID: D206-642-341

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 5/9/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/18/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: *mk*Date: *12-05-09*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2650

F

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-341 CHG003

N/A *[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 84295***84295***

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N9000040100Setup Start ***NS1***

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
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DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

Skidtubes

0.00

Skidtubes

Memo

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod M120164/M120854

4-Grind weld flush to cap on top surface only.

5-Cut aft end to length as per dwg D2650

6-Drill pilot holes using drill Jig DT8168A (A, & B) and DT8025. Open to Ø0.312"

7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

> CF 12-5-16

> BE 12-05-16

CF 12-5-16

Dart Aerospace Ltd

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

115

QC5- Inspect part completeness to step on W/O

0.00

115

QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

125

QC7-Inspect Chemical Conversion Coat

0.00

125

QC

Memo

0.00

Quality Control

WG 12-5-17

① SAG 12-05-22

W/O:		WORK ORDER CHANGES					
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Required Date: 5/18/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Skidtubes	0.00							
130									
Skidtubes	Memo	0.00							
Skidtubes	1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid)								
	2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)								
	3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.								
	4-Bond D2654-5 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting Start Date: <u>12-5-22</u> Time: <u>15:30</u> Finish Date: <u>12-05-23</u> Time: <u>10:00</u> A/RSikaflex-291 <u>MB1221</u> Sikaflex expiry date: <u>13-1-4</u>								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									

CF 12-5-22

CF 12-5-22

1 0 BE 12/05/23

W/O:		WORK ORDER CHANGES					
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1

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00

150

Skidtubes

Skidtubes

Memo

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
A/RAluminum Rod *m/20164*

BE 12/05/23

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

-> CF 12-5-23

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Deburr

D 12-5-23

4- Install nut plate as per dwg

-> CF 12-5-23

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

S 12/07/30

W/O:		WORK ORDER CHANGES					
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1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

190

Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.00

Hand Finishing

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

195

Spray Painting per QSI005 4.2

0.00

195

SprayPaint

Memo

0.00

Spray Painting

PRIME B# 117319
DELFLEET BLUE 121149
CLEAR DELFLEET 121703

1 26 12530

AB 12-7-15 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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1

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1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

205

QC14- Inspect Spray Paint

0.00

205

QC

Memo

0.00

Quality Control

DAS
16
9-29
12/10/16

W/O:		WORK ORDER CHANGES					
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N9000040100

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Revision ID:

Item Name: Replacement Skidtube

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NS2

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1

Cust Item ID:

Required Date: 5/18/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

0.00

220

HandFinish

HandFinishing

0.00

Memo

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/RSikaflex-291 121531

Sikaflex expiry date: 12/07

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/RSikaflex-291 121531

Sikaflex expiry date: 12/07

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch: 121505

1 8 (2P) 12/07/16.

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

QC3- Inspect Part Finish

0.00

230

QC

Memo

0.00

Quality Control

240

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

0.00

Quality Control

250

Packaging

0.00

250

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-341

Location:

PPP Rev:

PPP 84294

127726

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC21- Final Inspection - Work Order Release

0.00

260

QC

Memo

0.00

Quality Control

12/7/309
mf
12-07-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 1

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 Parent Item Name: Replacement Skidtube

Start Date: 5/9/2012

Required Date: 5/18/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: H05.10.11Added D3429-1 per CHG004KJ/CP/JLM
 IPP Rev:I 08-09-29 revF as per dwg DD verified by:EC Est Rev:J 09-03-02 as per DSI9440
 rev.a DD verified by:EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD416 Washer	* NAS1149D0463J ✓	Purchased	No				Each	30.0000		1		12/07/16	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351	121912 ✓	30							
					116289	10							
					119097	20							
CCR264SS3-3 Cherry Rivet		Purchased	No				Each	405.0000		2		CF 12-5-23	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST331		405							
					113973	2							
					117849	93							
					119017	310							
CR3212-4-03 Cherry Rivet		Purchased	No				Each	1,318.0000		2		CF 12-5-23	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP002		364							
					114859	364							
				ST331		954							
					110139	2							
					119017	952							

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Start Date: 5/9/2012

Required Date: 5/18/2012

Start Qty: 1.00

Required Qty: 1.00

D2620
Skidtube, 206 Skidtube

Manufactured No

Each 30.0000

1 CF 12-5-15

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	30	
79543	2	
79544	1	
81365	1	
82028	1	
82517	5	
82518	20	

D2647
Cap

Manufactured No

Each 92.0000

1

BE 12-05-16

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG002	92	
75482	4	
79563	88	

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Start Date: 5/9/2012

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Start Qty: 1.00

Required Qty: 1.00

D2649
Cross Bolt Spacer

Manufactured No

Each 640.0000

19

BE 12-05-23

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	420	
77574	2	
79502	8	
79503	399	
79564	4	
79565	7	
LG001	220	
65317	1	
68224	2	
68507	11	
71355	2	
72704	2	
72841	11	
73390	8	
73857	21	
73858	53	
73859	4	
73860	4	
78020	6	
78583	2	
79566	93	

19

D2654-5
Web

Manufactured No

Each 2.0000

1

CF 12-3-22

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	2	
82127	1	
82128	1	

①

D2680-041
Nut Plate

Manufactured No

Each 101.0000

① 1

CF 12-5-23

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST013	101	
78016	101	

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Dart Aerospace Ltd

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Required Date: 5/18/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

Each

1,393.0000

Screw

2 2 12/07/16

Location

Loc Qty

Loc Code

ST291	1393
117423	81
119075	1
120308 ✓	700
121011	111
121243	500

MS27039C1-08

Purchased

No

Each

1,258.0000

SCREW

54 54 12/07/16

Location

Loc Qty

Loc Code

FP002	1
116022	1
ST292	1238
120308	354
121068	108
121162 ✓	776
ST293	19
116373	3
118077	14
119309	2

ALS4-1032-130

Purchased

No

220

Each

3,895.0000

Insert

54 54 12/07/16

Location

Loc Qty

Loc Code

ST280 12444 ✓	205
119084	116
120671	89
ST281	690
120807	36
120837	654
ST282	3000
121269	3000

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 5

Work Order ID: 84295

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 5/9/2012

Required Date: 5/18/2012

Start Qty: 1.00

Required Qty: 1.00

AN960C10L	* NAS1149C0332R ✓	Purchased	No	122063 ✓	220	Each	0.0000
washer							
AN960JD10L	* NAS1149D0332A ✓	Purchased	No	121011 ✓	220	Each	0.0000
Washer							
D2646		Manufactured	No		220	Each	47.0000
Aft Cap							

54	54	12/07/16
2	2	12/07/16
1	1	12/07/16

Location	Loc Qty	Loc Code
FP002 81974 ✓	47	
62678	5	
68280	5	
70945	1	
71070	2	
73294	1	
73825	2	
78018	8	
79562	23	

D2651-1		Manufactured	No		220	Each	505.0000
Plug							

14	14	12/07/16
----	----	----------

Location	Loc Qty	Loc Code
FP	200	
FP001	461	
57869	1	
66445	10	
69018	2	
70827	2	
70839	8	
71037	8	
77559	30	
78584	18	
79234 ✓	82	
FP-A	-156	
77559	1	
78124	5	
81954	138	
82573	200	

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 6

Work Order ID: 84295

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 5/9/2012

Required Date: 5/18/2012

Start Qty: 1.00

Required Qty: 1.00

D2651-3	Manufactured	No	220	Each	1,282.0000	14	14	12/07/16
O-Ring								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			FP001	16				
			61962	12				
			73828	4				
			FP-A	1266				
			78126 ✓	1266				
D3535-11	Manufactured	No	220	Each	17.0000	1	1	12/07/16
Wearshoe								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			FP001	17				
			79058	1				
			82153 ✓	16				
D3535-23	Manufactured	No	220	Each	28.0000	1	1	12/07/16
Wearshoe								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			FP001	28				
			81355	8				
			83375 ✓	20				
D3535-35	Manufactured	No	220	Each	38.0000	1	1	12/07/16
Wearshoe								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			FP001	38				
			67598	1				
			70815	1				
			78873	13				
			79849	1				
			82064	5				
			83638 ✓	17				

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 7

Work Order ID: 84295

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 5/9/2012

Required Date: 5/18/2012

Start Qty: 1.00

Required Qty: 1.00

D3536-11 Manufactured No 220 Each 18.0000 1 1 DP 12/07/16
Gasket

Location	Loc Qty	Loc Code
FP002	18	
46649	1	
46715	4	
65574	1	
80006	3	
82152 ✓	9	

D3536-23 Manufactured No 220 Each 23.0000 1 1 DP 12/07/16
Gasket

Location	Loc Qty	Loc Code
FP002 85295 ✓	23	
74510	1	
80334	2	
83377	20	

D3536-35 Manufactured No 220 Each 26.0000 1 1 DP 12/07/16
Gasket

Location	Loc Qty	Loc Code
FP002 85605 ✓	26	
81340	12	
82065	14	

D3537-1 Manufactured No 220 Each 80.0000 6 6 DP 12/07/16
Wearpad

Location	Loc Qty	Loc Code
FG 85457 ✓	10	
79833	10	
FP002	70	
69817	5	
81362	55	
83254	1	
83255	9	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 8

Work Order ID: 84295

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 5/9/2012

Required Date: 5/18/2012

Start Qty: 1.00

Required Qty: 1.00

D3537-3 Manufactured No 220 Each 34.0000

Wearpad

1 1 20 12/07/16

Location

Loc Qty

Loc Code

FP002 85481 ✓
78836
81363

34
11
23

MS27039-4-06

Purchased

No

220 Each 133.0000

Screw

1 1 20 12/07/16

Location

Loc Qty

Loc Code

ST292
119075 ✓

133
133

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

#84295

RELEASED
08-07-23

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

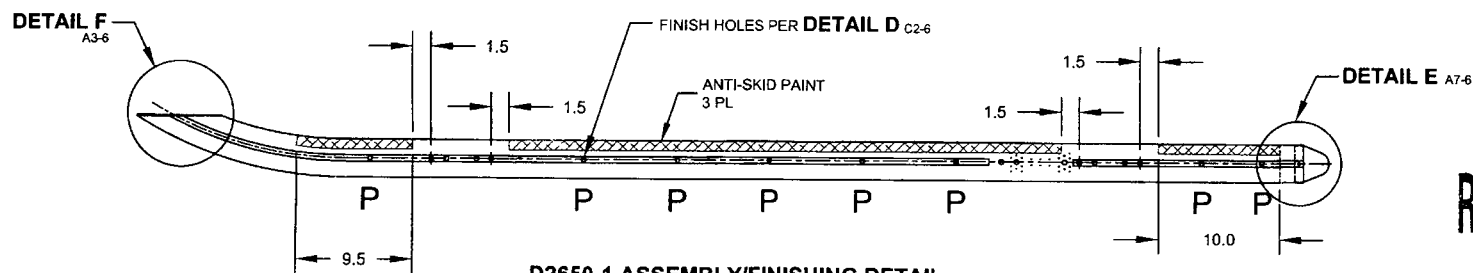
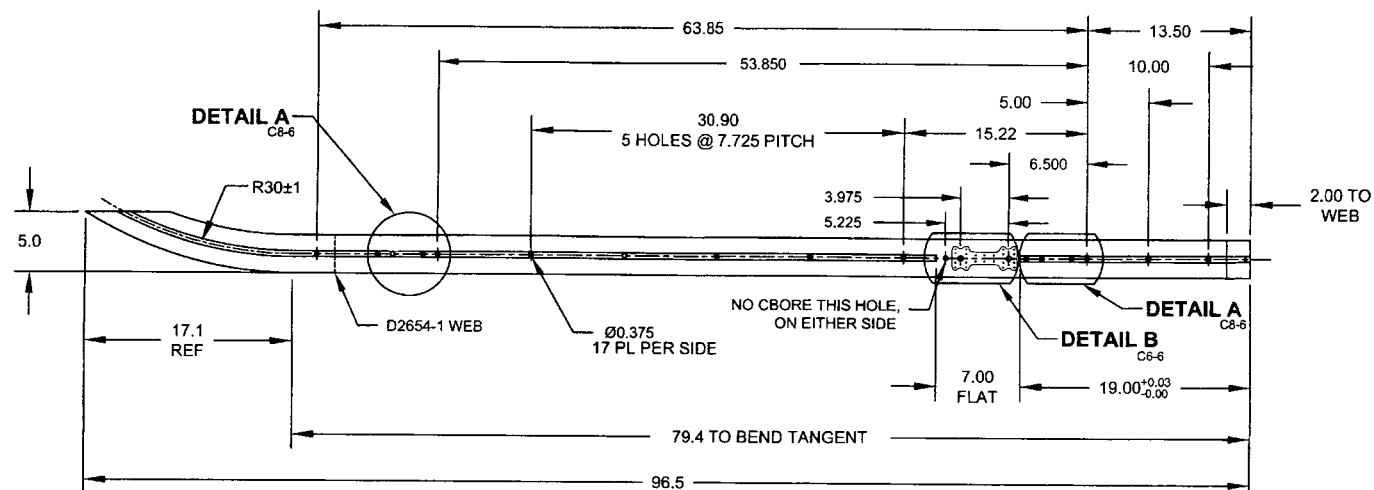
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
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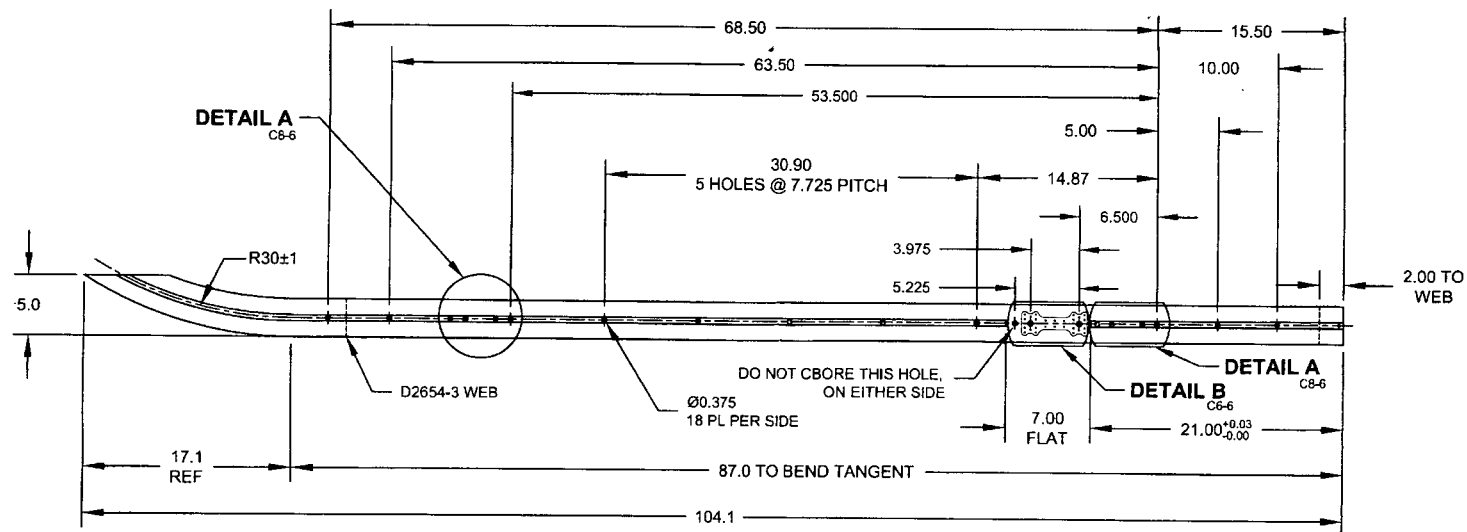
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

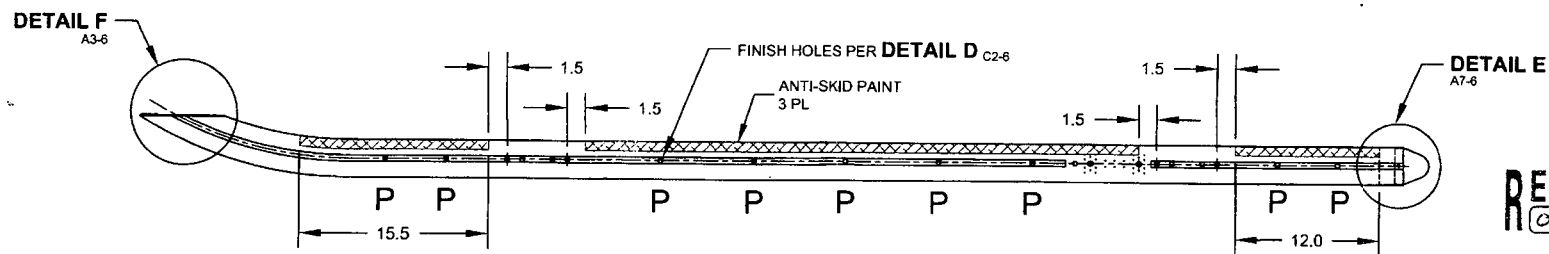
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-3 BENDING/DRILLING DETAIL



D2650-3 ASSEMBLY/FINISHING DETAIL

#84295

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DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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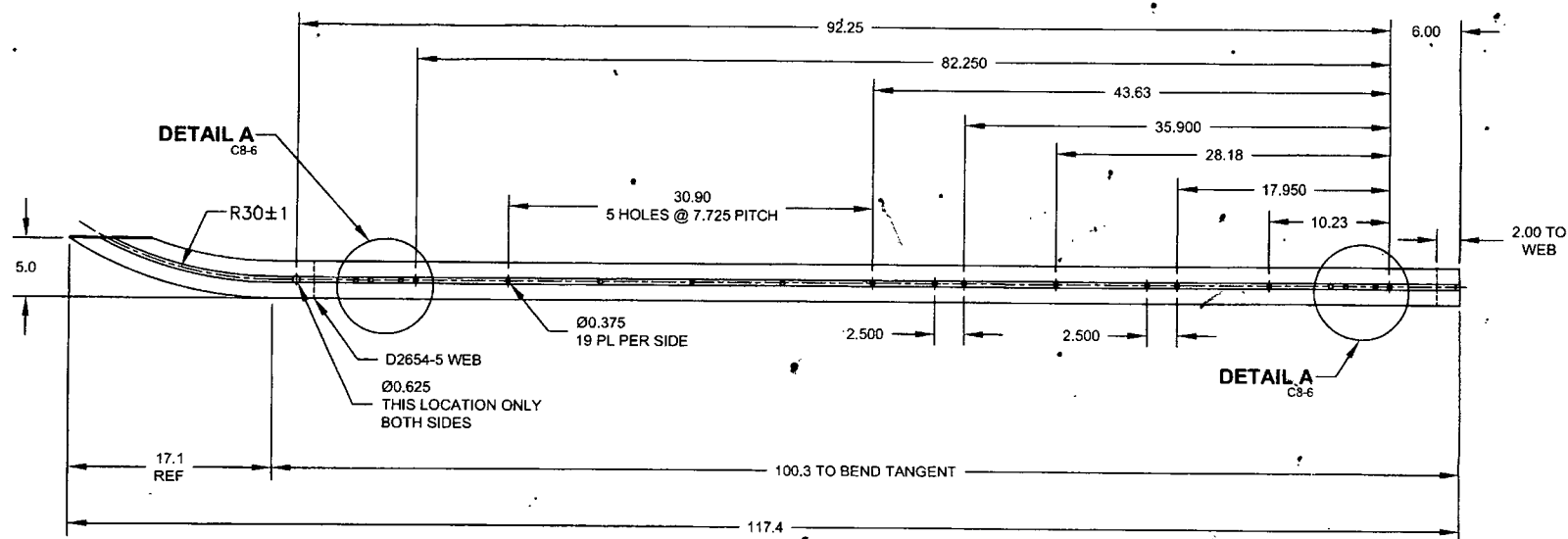
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

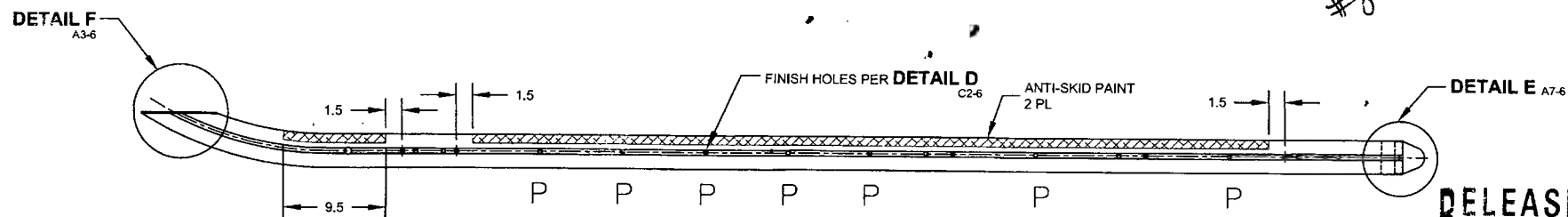
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	E	D2650	SHEET 4 OF 6
APPROVED	AP	TITLE	SCALE
DE APPR.	#	206/407 SKIDTUBE ASSEMBLIES	NTS
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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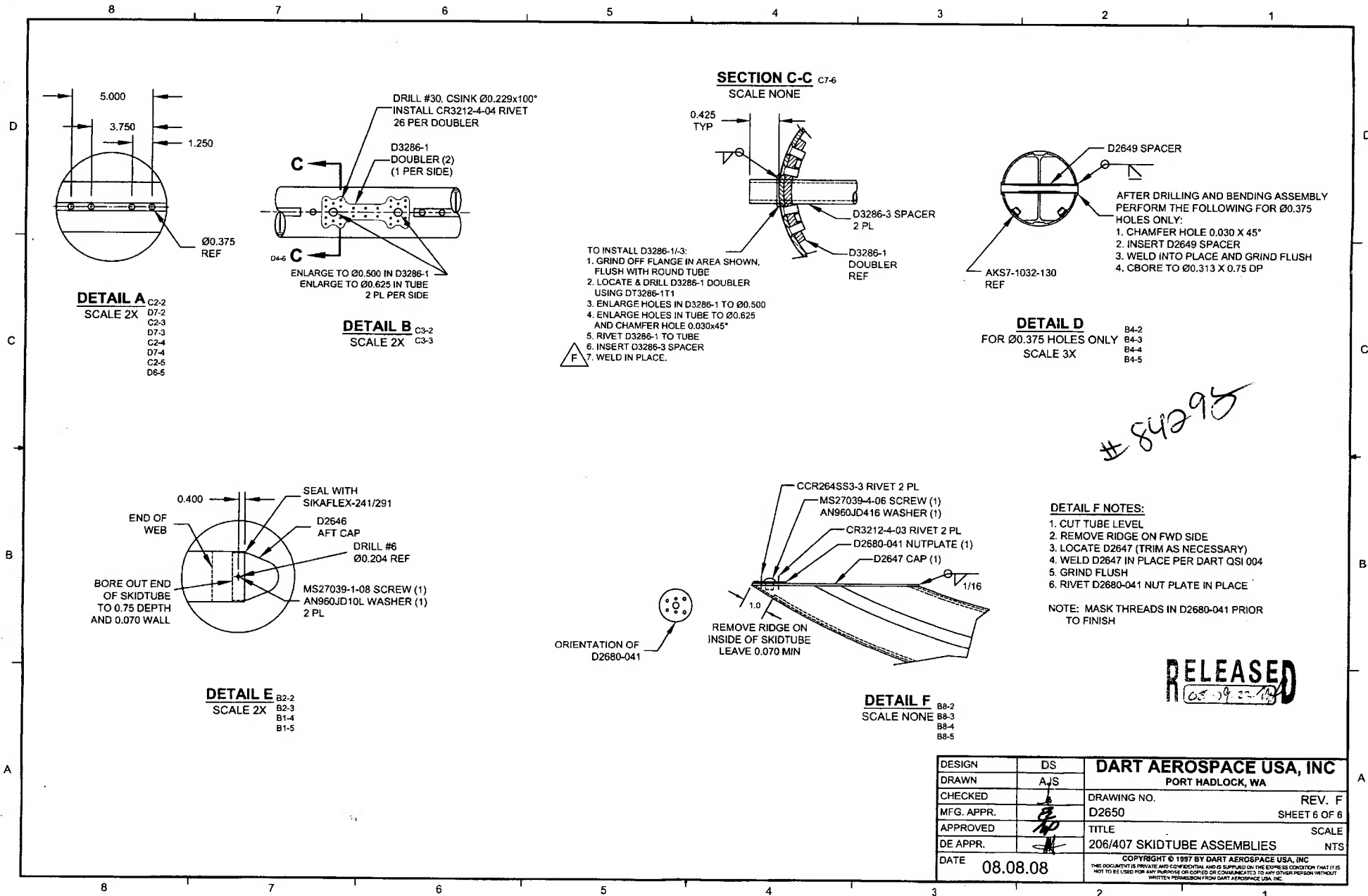
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NOTE: Date & initial all entries

NO. 295

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 83028
Part number: A206-642-241
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum.
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier [Signature] Date of Test Coupon 12.05.23
Welder Barclay Elliott Date of Test Coupon 12.05.23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld